



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ordn 2134 July 31

D3023-1

Job Sheet 180305



Part No: D3023-1

Job Qty: 2 ea

Part Name: Back Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 02.01.23 Revised NG IPP Rev:D 08-04-16 now water jet DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Waterjet		SC 8/6/17
100	Waterjet	2 pcs	7/20/18	7/20/18	0.34	1.08	Waterjet1		SC 8/6/17
110	QC	2 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Waterjet-1		SC 8/6/17
120	QC	2 pcs	7/20/18	7/20/18	0.00	0.00	QC8-1		38
130	Brake NC	2 pcs	7/20/18	7/20/18	0.00	0.39	Brake NC 1		9-89 DAS
140	QC	2 pcs	7/20/18	7/20/18	0.00	0.00	QC5		38
180	Packaging	2 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3		9-89
190	QC21-SA	2 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21 AUG 27 2018

Part Op 100 - 1-Cut as per Dwg D3023 ***grain direction along 28.100" ***
Descriptions: 180 - LOCATION: WA001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	11.4000 sf (5.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.032	11	70	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Back Panel	0.128Inches + 0.005 - 0.001	0.133 0.127	0.130 Diameter	
2	Back Panel	0.191Inches + 0.005 - 0.001	0.196 0.190	0.192 Diameter	
3	Back Panel	1.660Inches ± 0.010	1.670 1.650	1.666	
4	Back Panel	0.375Inches ± 0.010	0.385 0.365	0.378	
5	Back Panel	1.340Inches ± 0.010	1.350 1.330	1.344	
6	Back Panel	2.375Inches ± 0.010	2.385 2.365	2.379	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		MRB (QSI042) Approval	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S092907 Part: D3023-1 Job No: 180305 Serial No/Batch: S092907 Date: 07/17/10		Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
				Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	

7	Back Panel	0.375Inches ± 0.010	0.385 0.365	0,378
8	Back Panel	25.280Inches ± 0.030	25.310 25.250	25,28
9	Back Panel	27.030Inches ± 0.030	27.060 27.000	27,030
10	Back Panel	28.100Inches ± 0.030	28.130 28.070	28,100
11	Back Panel	1.300Inches ± 0.030	1.330 1.270	1,302
12	Back Panel	2.375Inches ± 0.010	2.385 2.365	2,377
13	Back Panel	8.711Inches ± 0.010	8.721 8.701	8,715
14	Back Panel	5.597Inches ± 0.010	5.607 5.587	5,600
15	Back Panel	8.570Inches ± 0.030	8.600 8.540	8,573
16	Back Panel	1.970Inches ± 0.010	1.980 1.960	1,974
17	Back Panel	7.420Inches ± 0.030	7.450 7.390	7,420 7,422
18	Back Panel	10.920Inches ± 0.030	10.950 10.890	10,920
19	Back Panel	14.750Inches ± 0.030	14.780 14.720	14,75

Plex 7/4/18 11:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								